

Work Order ID 61152

Tuesday, August 10, 2010 8:39:27 AM



Page 1

Item ID:	D350-591-311	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Long LH					
Start Date:	8/11/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	9/15/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>0-8-10</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-311 CHG002								
									CHG001

Handwritten: J for BG 10-9-20

110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R <input type="checkbox"/> Aluminum Rod <u>M112860</u>								
	<u>M114877</u>								
	3-Grind End Plate flush								

Handwritten: 10-08-13

Handwritten: 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-591-311

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 8/11/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

x10 - 10/09/13 BE

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.13

x10
CH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10.08.13

10 J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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150

QC3- Inspect Part Finish

0.00

⇒ M

10/09/13

104 0



QC

Memo

0.00

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

10.09.15

10 0

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M112860

6-Grind End Plate flush

7-Install last rivet as per Dwg.

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

* 10 - BE 10/09/16

200

QC5- Inspect part completeness to step on W/O

0.00



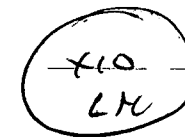
QC

Memo

0.00

Quality Control

Siolorlu



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/09/16



Dart Aerospace Ltd

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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M114841 M115028</i> Memo START TIME: <i>10:15</i> OVEN TEMPERATURE: <i>3200</i> FINISH TIME: <i>10:45</i>	0.00 0.00	<i>BR 10-9-17</i>			<i>(10)</i>	<i>0</i>		
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M115028</i> Memo	0.00 0.00	<i>M 10/09/20</i>			<i>(1064)</i>	<i>0</i>		
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>8/10/21</i>			<i>110</i> <i>LM</i>			

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	Pick Kit	0.00							
Packaging 	Memo	0.00							
260 	QC4- 100% Inspect kits for completeness	0.00							
QC 	Memo	0.00							
Quality Control									
270 	Packaging	0.00							
Packaging 	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311 Location: _____								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 9/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

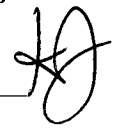


QC

Memo

0.00

Quality Control

10/09/21 
MF
10-9-21

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, August 10, 2010 8:39:26 AM

Parent Item: D350-591-311




Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/11/2010**Required Date:** 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-35A  Bolt		Purchased	No			250	Each	113.0000	2	20		10/9/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST353				113					
				115016				13					
				115108				100					
AN4-13A  Bolt		Purchased	No			250	Each	894.0000	8	80		10/9/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				394					
				115108				394					
				ST358				500					
				115159				500					
AN5-36A  Bolt		Purchased	No			250	Each	173.0000	2	20		10/9/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST341				173					
				114292				5					
				114941				168					

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 61152

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD10 NAS1149D0363J Purchased No

250

Each

6.0000

4

40



S

Washer



M113600

10/9/178

Location

Loc Qty

Loc Code

ST

6

107715

6

AN960JD416 NAS1149D0463J Purchased No

250

Each

0.0000

16

160



S

Washer



M115000

10/9/178

AN960JD516 NAS1149D0563J Purchased No

250

Each

34.0000

4

40



S

Washer



M11742

10/9/178

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2230-3 Manufactured No

250

Each

109.0000

4

40



S

Dug



32x B60846

10/9/178

Location

Loc Qty

Loc Code

ST476

109

55452

2

59418

8

60191

99

B61198 3x

100

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Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

D2618

Manufactured No

250

Each

189.0000

2

20



Bushing



10/9/17 \$

Location

Loc Qty

Loc Code

ST019

187

60193

73

60772

114

ST020

2

56892

1

57829

1

20

D2856-400

Manufactured No

250

f

340.9788

0.6



Abraison Strip



10/9/17 \$

Location

Loc Qty

Loc Code

ST403

340.9788421

56626

124.978842

59920

216

6

D3065-041

Manufactured No

180

Each

6.0000

1

10



Step Leg Assembly Hi



10.09.15

Location

Loc Qty

Loc Code

WA

340260

6

58536

4

59678

2

10

D3066-1

Manufactured No

180

Each

89.0000

2

20



Spacer



10.09.15

Location

Loc Qty

Loc Code

WA

89

58540

23

60194

66

20

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Page 3

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/11/2010

Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

110

Each

132.0000

1

10



End Plate



10.08.13

Location

Loc Qty

Loc Code

WA

132

60141

132

D3067-1

Manufactured No

180

Each

132.0000

1

10



End Plate



10.09.15

Location

Loc Qty

Loc Code

WA

132

60141

132

D3219-1

Manufactured No

110

Each

27.0000

2

20



Plate



10.08.13

Location

Loc Qty

Loc Code

WA

27

360859

27

D3235-1

Manufactured No

250

Each

93.0000

2

20



Mounting Lug



20 10/9/17 SP 100

Location

Loc Qty

Loc Code

ST471

93

59125

13

60195

40

60490

40

D3272-1

Manufactured No

110

Each

0.0000

1

10



Step



10.09.09 361149

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Required Date: 9/15/2010

Start Qty: 10.00

Required Qty: 10.00

D3278-041 Manufactured No

250

Each

55.0000

1

10



Support Assembly



10/9/17 SP
25

Location

Loc Qty

Loc Code

ST471

55

59633

15

60201

40

X1
10/9

MS20600-AD4W4 Purchased No

180

Each

179.0000

16

160



Rivets



10.09.15

Location

Loc Qty

Loc Code

ST321

179

113368

62

114181

11

114718

2

114935

104

160

MS21042L3 Purchased No

250

Each

2,426.000

2

20



Nut



10/9/17 SP

Location

Loc Qty

Loc Code

ST300

2426

114523

115

114718

311

114784

2000

160

20

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Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

3,263.000

8

80



10/9/11 SF

Location

Loc Qty

Loc Code

ST300

3263

113422

68

114523

28

114718

16

114784

1151

115108

2000

MS21042L5

Purchased

No

250

Each

738.0000

2

20



10/9/11 SF (10x)

Location

Loc Qty

Loc Code

ST139

238

114813

238

ST300

500

115156

500

20

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DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

#61152

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

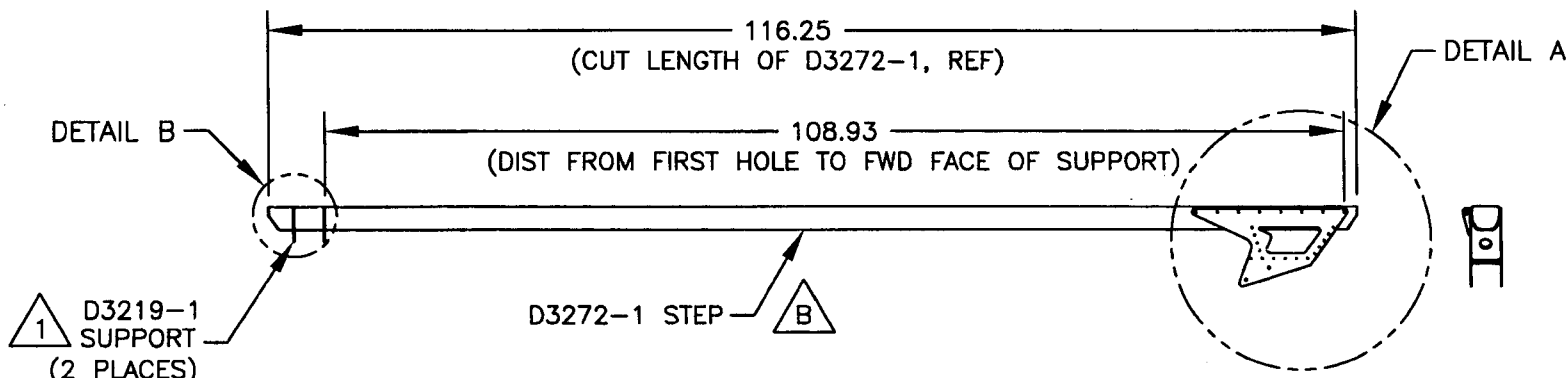
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

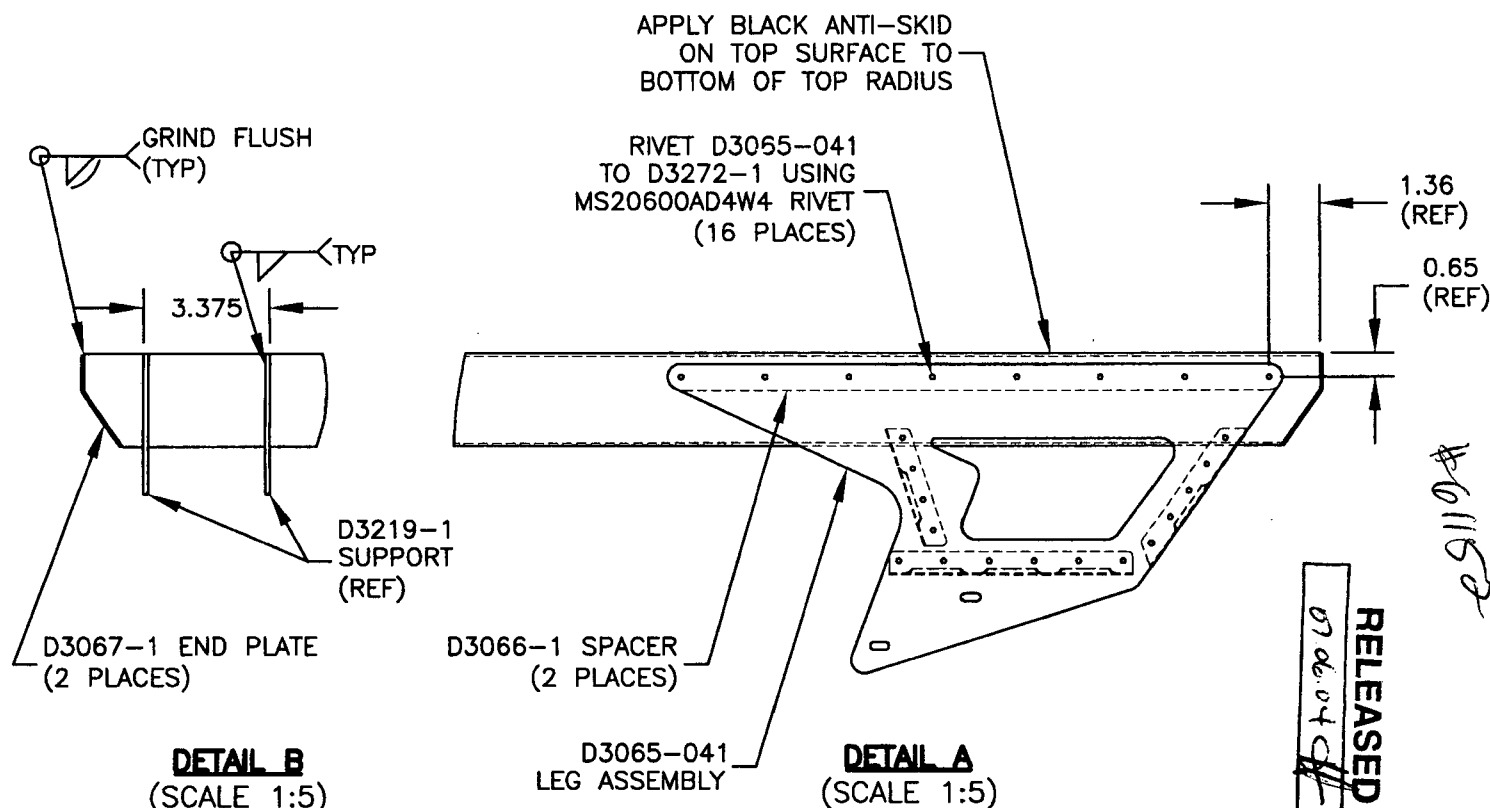
NOTE: Date & initial all entries

DART

DESIGN	90	DRAWN BY	J.B.	DART AEROSPACE LTD.
CHECKED	CE	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

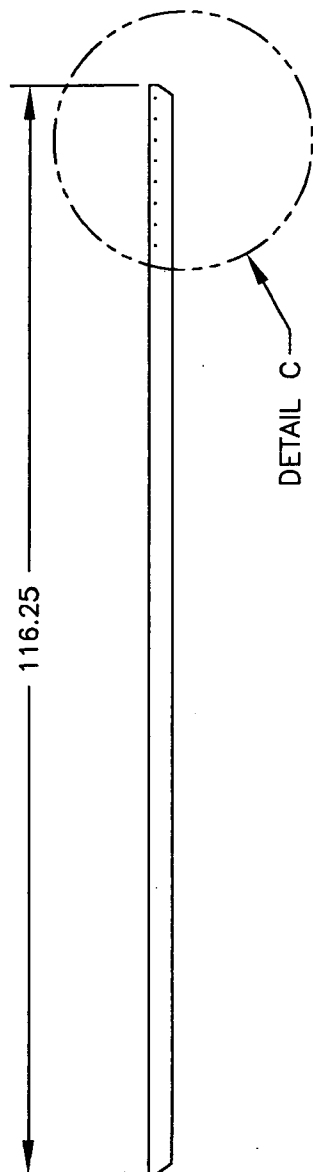


DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

#61152

RELEASED

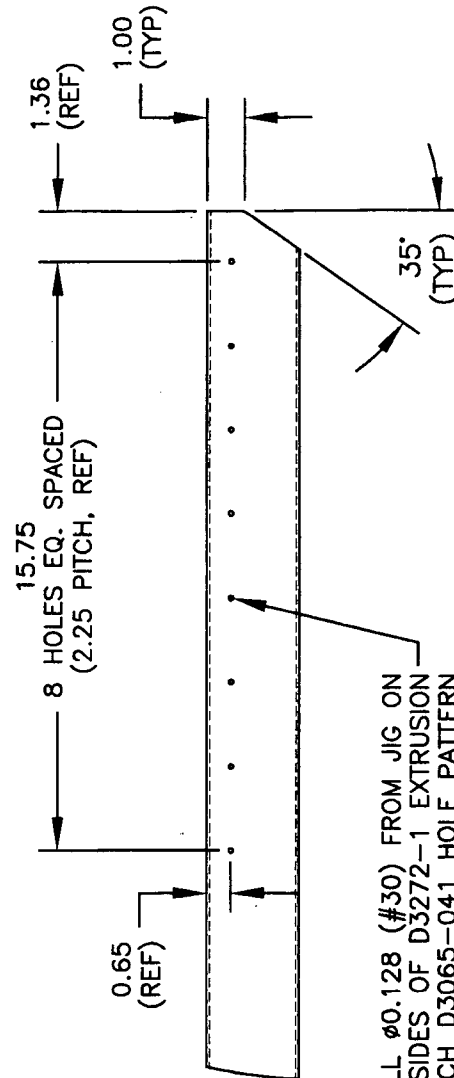
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C

(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**
Date: 08.10.06